

ship Sept. 29

Work Order ID 151349

151349

Page 1

Friday, September 23, 2016 10:50:33 AM

Item ID: D4640-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: LH Wall Protector
Start Date: 9/26/2016 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/27/2016 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: dm Date: 16/09/23 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4640	D

100

0.02

100

Waterjet

FLOW CNC Waterjet

Memo

0.09

***Confirm if parts are trimmed or untrimmed prior to cutting ***

Cut as per dwg

Prog Rev: P

Dwg Rev: P

Deburr as required

2

PR 16/09/27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

2

PR 16/09/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						2			SEP 28 2016
QC	Memo	0.01							
Quality Control	USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT MARKER ON TEXTURED SIDE								
130	Identify as per dwg & Stock Location: _____	0.00							
130						2X			DAS 28 9-89
Packaging	Memo	0.00							SEP 28 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
140									SEP 28 2016
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

SEP 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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151349

Parent Item: D4640-5

D4640-5

Parent Item Name: LH Wall Protector

Start Date: 9/26/2016

Required Date: 9/27/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC
12.10.17 AS PER REV.B VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased			No	100	sf	1,664.166	16	33.68421			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (LIGHT GREY)

PR 16/09/27

Location

Loc Qty

Loc Code

MAT023

69.56

m129738

69.56

therm

1594.6066

m135322

623.94

m135517

970.6666

35.7

DQA: _____ Date: _____

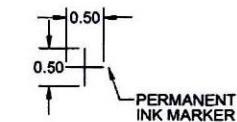


WORK ORDER NON-CONFORMANCE / UPDATE

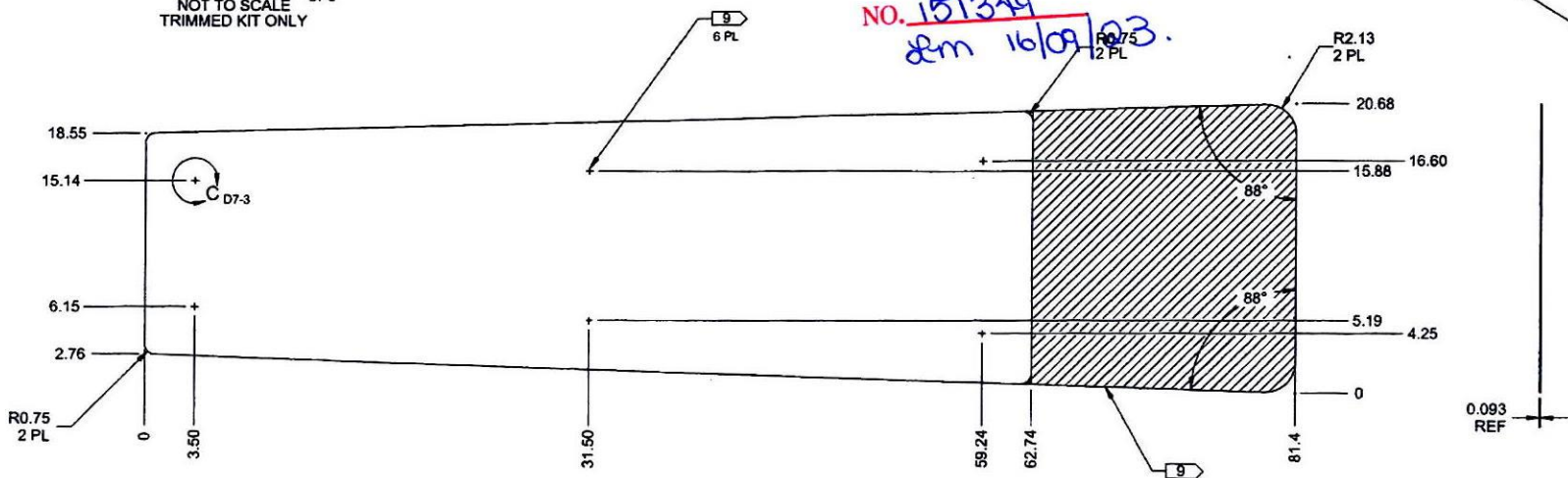
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Past Expiry Date ☐	Manufacturing Process ☐				
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151349
2m 16/09/03.



D4640-5 LH WALL PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 6.00 lbs (TRIMMED WEIGHT = 4.49 lbs)
- 8) CHECK PER TEMPLATE DT8926
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA

RELEASED
2013-01-10
MP

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D4640	SHEET 3 OF 9
MFG. APPR.		TITLE	SCALE
APPROVED		BAGGAGE PROTECTOR	NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.12.18		